

Work Order ID 137569

137569

Page 1

Item ID: D350-636-047

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 10/6/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: SH Date: 12/01/2015 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D350-636	J

100	Document Control	0.00	DAS 8 9-89						
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork		Photocopy bluefile & type labels per PPPD350-636-047 CHG005							

MLJ 15-12-04
6X DAS 28 9-89 DEC 07 2015

110	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

110									
Packaging	Memo	0.00							
Packaging									

6X DAS 27 9-89 DEC 03 2015

115	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

115									
QC	Memo	0.00							
Quality Control									

6X DAS 28 9-89 DEC 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 137569

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137569

Page 2

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Revision ID:

Item Name: Run-on Landing Wearplates Fits LH or RH

Stop ***NS2***

Start Date: 10/6/2015 Start Qty: 6.00

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-636-047 Location: FG041								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.01							
Quality Control									

6x DAS 28 9-89 DEC 07 2015

MCS DEC 07 2015

MCS DEC 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

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Page 1

Work Order ID: 137569

137569

Parent Item: D350-636-047

D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 10/6/2015

Required Date: 10/13/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 10.09.27 NEW ISSUE DD VERF:EC IPP
Rev:B 11.04.14 ecn11-553 DD verf:EC IPP REV:C AS
PER ECN 11-603 JLM 11.07.07 VERIFIED BY:DD IPP Rev:D 112.04.16
AS PER ECN 12-542 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-041		Manufactured	No			110	Each	0.0000	1	6			
D4154-041									**	138703			DAS 27 9-89
Wearplate Assembly													
AN3C36A		Purchased	No			110	Each	334.0000	4	24			
AN3C36A									**	131657			DAS 27 9-89
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				47					
				101261				4					
				122204				2					
				m131367				1					
				m132169				40					
				FP001				43					
				m131856				43					
				ST338a				240					
				131651				80					
				m129907				4					
				m131856				4					
				m132381				80					
				m132522				72					
				ST347				4					
				m130874				4					

DAS
28
9-89

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Work Order ID: 137569

137569

Parent Item: D350-636-047

D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 10/6/2015

Required Date: 10/13/2015

Start Qty: 6.00

Required Qty: 6.00

AN3C37A

Purchased

No

110

Each

477.0000

1

6

AN3C37A

BOLT

12482724

DAS
6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST338a

476

131651

70

M128773

1

M129650

55

M131367

70

M131856

70

M132169

70

M132381

70

M132522

70

2

ST347

1

129687

1

DAS
6
9-89

AN3C42A

Purchased

No

110

Each

76.0000

1

6

AN3C42A

Bolt

BAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

121103

5

ST338a

52

m130485

3

m131856

10

m132381

9

m132522

10

m132674

10

m133091

10

ST346

19

m131854

9

~~m131855~~

10

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Work Order ID: 137569

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Parent Item: D350-636-047

D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 10/6/2015

Required Date: 10/13/2015

Start Qty: 6.00

Required Qty: 6.00

NAS1149C0363R

Purchased

No

110

Each

1,133.000

10

60

128401

40

8

1-89

NAS1149C0363R

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

60

114742

60

GA

506

m133077

506

ST260a

494

m133077

494

ST271

73

m130673

20

m132763

53

54

6

MS21043-3

Purchased

No

110

Each

814.0000

5

30

MS21043-3

Nut

28
9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

11

m130673

11

GA

139

m130673

15

m131677

124

ST304

547

m131340

180

m133031

367

ST308

37

m132551

37

30

DAS

8

9-89

DAS

27

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Shop Packet Print

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Parent Item: D350-636-047

D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 10/6/2015

Required Date: 10/13/2015

Start Qty: 6.00

Required Qty: 6.00

D3873-1

Manufactured No

110 Each

41.0000

8

48

D3873-1

Bushing

**

138215

DAS

27

9-89

Location

Loc Qty

Loc Code

FP001

19

126709

2

135402

17

ST063

22

129742

16

134885

6

DAS

6

9-89

D4171-1

Manufactured No

110 Each

22.0000

1

6

D4171-1

Bushing

**

DAS

27

9-89

Location

Loc Qty

Loc Code

ST088

22

129060

22

DAS

6

9-89

D4170-3

Manufactured No

Each

25.0000

4

24

D4170-3

Bushing

**

4

24

137770x9

DAS

6

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST088

10

123100

10

ST096

15

135749

3

135922

12

DEC 03 2015

3
12

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D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 10/6/2015

Required Date: 10/13/2015

Start Qty: 6.00

Required Qty: 6.00

AN3C34A

Purchased

No

110

Each

17.0000

1

6

AN3C34A

BOLT

13483 x 3

DAS
6
9-89

SMB

DAS
28
9-89

Location

Loc Qty

Loc Code

ST348

17

m127044

1

m131618

6

m133077

10

3

DEC 03 2015

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
***43	2	2	2	2		D3493-1	WASHER
*90	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1	1	AN3C42A	BOLT ³
*92	7	7	7	7	8	AN960C10	WASHER (OR NAS1149CO363R)
92A			1	1		AN960C10	WASHER (OR NAS1149CO363R) ³
*93	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	8	D3873-1	BUSHING
94A			1	1		D3873-1	BUSHING ³
*95	1	1	1	1	1	D4171-1	BUSHING ⁴
96					4	D4170-3	SPACER
*97	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	AN960C10	WASHER (OR NAS1149CO363R)
*99	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH APICAL CYLINDRICAL OR TRI-BAG FLOATS² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL CYLINDRICAL BAG FLOATS³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS

8.0 PARTS LIST (D350-636-015/-016/-017/-018/-047 KITS)

DAS
28
9-89

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
	X					D350-636-015	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE W/ TRAINING WEARPLATE
		X				D350-636-016	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE W/ TRAINING WEARPLATE
			X			D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE W/ TRAINING WEARPLATE
				X		D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE W/ TRAINING WEARPLATE
					X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1					D4168-041	SKIDTUBE ASSEMBLY, LH
1		1				D4168-042	SKIDTUBE ASSEMBLY, RH
1			1			D4168-043	SKIDTUBE ASSEMBLY, LH
1				1		D4168-044	SKIDTUBE ASSEMBLY, RH
*1	1					D4168-1	SKIDTUBE WELDMENT, LH
*1		1				D4168-2	SKIDTUBE WELDMENT, RH
*1			1			D4168-3	SKIDTUBE WELDMENT, LH
*1				1		D4168-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23118AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN860C818L	WASHER (OR NAS1149CO832R)
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2		AN860JD816	WASHER (OR NAS1149CO863J)
12	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4		AN8C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN860C10L	WASHER (OR NAS1149CO332R)
*20B	4	4	4	4		NAS1515H3L	WASHER
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY

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